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D2563
Job Sheet 184658



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Large Fab-2		SLU
100	Large Fab	4 pcs	11/9/18	11/9/18	0.00	5.88	Large Fab 2		SLU
110	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC9		SLU
120	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC5		SLU
130	HandFinish	4 pcs	11/9/18	11/9/18	0.00	1.07	HandFinish1		O.R. 18/12/13
140	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC7		SLU
150	Large Fab	4 pcs	11/9/18	11/9/18	0.00	5.88	Large Fab 2		CC
160	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC10		SLU
170	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC5		SLU
175	HandFinish	4 pcs	11/9/18	11/9/18	0.00	1.07	HandFinish2		DR 18/12/16
180	Powdercoat	4 pcs	11/9/18	11/9/18	0.00	0.67	Powdercoat1		DR 18-12-17
190	HandFinish	4 pcs	11/9/18	11/9/18	0.00	1.07	HandFinish3		DR 18-12-18
200	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC3		DAS 21 DEC 17 2018 68
210	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3		DAS 21 DEC 18 2018
220	QC21-SA	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		DAS 21 DEC 19 2018

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind
175 - Touch up Alodine as per QSI005
180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME:

M 138951

START: 8:20 O.V.T. 320° FINISH: 8:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 Ea (1 ea)	90-Start up Operation	B164533-75
D2561	Lug	8 Ea (2 ea)	90-Start up Operation	S122010
D2564	Mounting Angle	8 Ea (2 ea)	90-Start up Operation	S124417
D2673-34	End Plate	4 Ea (1 ea)	90-Start up Operation	S075838
D2673-34	End Plate	4 Ea (1 ea)	150-Large Fab	S077409

Wing walk 1138963

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	4	26	0
	D2561	8	8	0

6709

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

150-Large Fab

D2564
D2673-34
D2673-34

8
4
4

6
39
39

0
0
0

Part Specifications

Specifications could not be found.

Plex 10/15/18 3:03 PM Dart.lajeunesse.marie

QA Closed: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Container No: S132402				FAULT CATEGORY					
Part: D2563				☐ Power Loss/Surge			☐ Positioned Wrong		
Job No: 184658				☐ Folio/Program			☐ Outside Dimensions		
Serial No/Batch: S132402				☐ Grain			☐ Over/Under tolerance		
Revision:				☐ Weld			☐ Part Incorrect		
Inspector:				☐ Wrong Stock Pulled			☐ Part Lost/Missing		
Exp Date:				☐ Out of Sequence			☐ Part Moved		
Instructions: Various STC's				☐ Off-set			☐ Drawing		
				☐ Mislabeled			☐ Finish		
				☐ Fit/Function			☐ Misread		
				☐ Misaligned/off center			☐ Turning Sequence		